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D3913-041
Job Sheet 206487



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/31/20

Job Tracking No:

Due Date: 3/10/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP Rev:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	3/10/20		0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	3/10/20		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		DAS
							QC 9 - 50		43
							QC 9 - 9		9-89
120	QC 5	1	3/10/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		DAS
							QC 5 - 49		43
							QC 5 - 51		9-89

KS/CC



Container No: S259233



Part: D3913 - 041

Job No: 206487

Serial No/Batch: S259233

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/26/20

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						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
125 Handfinish - 2-1 Pressure-B4B	1 pcs	3/10/20	0.00	0.29	Handfinish - 2 - 1 - B4B	jsl 20-3-2	
					Handfinish - 2 - 2 - B4B		
					Handfinish - 2 - 3 - B4B		
					Handfinish - 2 - 4 - B4B		
130 Powdercoat - 2 White Gl(S)-B4B	1 pcs	3/10/20	0.00	0.93	Powdercoat - 1 - B4B	BE820-03-02.	
					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B		
					Powdercoat - 4 - B4B		
140 QC 3	1 pcs	3/10/20	0.00	0.00	QC 3 - 10		
					QC 3 - 13		
					QC 3 - 15	jsl 20-3-2	
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59		
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40		
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
					QC 3 - 82		
150 Handfinish - 4-1-Assembly-B4B	1 pcs	3/10/20	0.00	0.50	Handfinish - 4 - 1 - B4B	jsl 20-3-2	
					Handfinish - 4 - 10 - B4B		
					Handfinish - 4 - 11 - B4B		
					Handfinish - 4 - 12 - B4B		
					Handfinish - 4 - 13 - B4B		
					Handfinish - 4 - 14 - B4B		
					Handfinish - 4 - 15 - B4B		
					Handfinish - 4 - 2 - B4B		
					Handfinish - 4 - 3 -		
						Plex 1/31/20 11:15 AM Dart.lajeunesse.marie	

DAS
15
9-89

https://www.plexonline.com/63a9df10-937a-44c1-9752-4c5b51fce2ba/Plexus_Control/Report_Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=True... 3/5

					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
					180 QC 21 - SA	1
	pcs				QC 21 - SA - 70	21
					QC 21 - SA - 53	21

Part On 100 - W... MAR 02 2020

MAR 12 2020

Part Op 100 - Weld per dwg A/R S.S. rod Batch: M139023 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect
 Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to
 fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder
 coat
 140 - QC3- Inspect Part Finish
 150 - Assemble as per dwg - Pick Kit
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location:
 180 - QC21- Final Inspection - Work Order Release

5235590

START: 10:30 TEMP: 375° FINISH: 10:45

#014496

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5246180
D3913-1 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5252319
D3913-15 ✓	Wide Handle Plate	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5230185
D3913-3 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5252212
D3913-7 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5242323
D3913-9 ✓	Hinge Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5252343
D3916-041 ✓	Rib Assembly	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5253328
D3916-5 ✓	Light Rib	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5253596
D4016-1 ✓	Hinge Half, Base	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5242095
D4017-7 ✓	Rib	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5233319
D4017-9 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5243715
D4020-11 ✓	End Mesh, Basket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5245036
D4021-1 ✓	Handle Plate	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	5253605
D4034-041 ✓	Aft Upper Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5250611
D4034-043 ✓	Fwd Upper Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5255964
D4672-1 ✓	Blanking Plate	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5256099
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5236300
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5249345-1
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5016914
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5243985-1
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5216387
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5241506
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136362

OK

OK

OK

014772

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	60	0
	D3913-1	1	12	0
	D3913-15	1	15	0
	D3913-3	1	12	0
	D3913-7	2	22	0
	D3913-9	1	13	0
	D3916-041	2	4	0
	D3916-5	3	11	0
	D4016-1	3	6	0
	D4017-7	3	96	0
	D4017-9	2	8	0
	D4020-11	2	8	0
	D4021-1	3	8	0
	D4034-041	1	6	0
	D4034-043	1	3	0
	D4672-1	2	8	0
	M304EX0.75-16F	32	755	0
	AN3-10A	6	250	0
	D2931	2	519	0
	D4021-5	2	39	0
150-Handfinish - 4-1-Assembly-B4B	MS20600-AD4W3	2	770	0
	MS21042L3	6	3,081	0
	NAS1149F0332P	12	5,458	0
	NAS1149FN832P	2	6,042	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☐ Small Fab ☐ Large Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QS1042)																													
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition																													
Description Work Order Deviation																																			
Completed By																																			
Lead hand / Supervisor																																			
QC / QA Coordinator																																			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details: _____						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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